

Work Order ID 93837

November-27-12 11:47:40 AM

\*93837\*

Page 1

Item ID: D3212-1

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Floor Window

Start Date: 11/27/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: M65

Date: 12-11-28 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3212	C
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100	0.00	(S)	12-12-19
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*100*	FLOW WATER JET	0.00		
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Waterjet	Memo	0.00		
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FLOW CNC Waterjet	1-Cut blankas per Dwg D3212	Dwg Rev: C	Prog Rev: C	
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Plexiglass G .125"	2-Deburr if necessary			
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110	0.00	(S)	12-12-19
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*110*	HAAS CNC VERTICAL MACHINING #1	0.00		
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HAAS 1	Memo	0.00		
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HAAS CNC vertical machine #1	Machine as per Folio FA349 and Dwg D3212			
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120	0.00	(S)	12-12-19
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*120*	QC2- Inspect parts off machine FAI/FAIB	0.00		
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QC	Memo	0.00		
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Quality Control				
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NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS																			
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>					
Part No. _____			Work Order Update <input type="checkbox"/>																						
NCR No. _____																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance			Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector												
Doc/Data																									
Equip/Tooling																									
Operator																									
Material																									
Setup																									
Other																									
Process																									
Supplier																									
Training																									
Unapproved																									
FAULT CATEGORY																									
Landing Gear				General																					
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio										<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
																						<input type="checkbox"/> Other			

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November-27-12 11:47:41 AM

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Page 2

Item ID: D3212-1

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Floor Window

Stop

\*NS2\*

Start Date: 11/27/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

DAS  
33  
08

\*130\*

QC

Quality Control

140

Small Fab

0.00

SK

J.13/1/13

\*140\*

Small Fab

Small Fab

Memo

0.00

1-Deburr if necessary 2-Install label as per Dwg D32123- polish abrasion  
scratches if necessary.. 4-Wrap in plastic wrap after inspection

150

QC5- Inspect part completeness to step on W/O

0.00

DAS  
15  
0-89  
B-131

S

\*150\*

QC

Quality Control

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order ID 93837

November-27-12 11:47:41 AM

\*93837\*

Page 3

Item ID: D3212-1

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Floor Window

Stop

\*NS2\*

Start Date: 11/27/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

\*160\*

Packaging

Packaging

Identify as per dwg & Stock Location: ST

0.00

210

0.00

11/30/13 5

170

\*170\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/30/13 D

PLB-0131

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset	Other								
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

# Picklist Print

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Page 1

Work Order ID: 93837

Parent Item: D3212-1

Start Date: 11/27/12

Required Date: 12/07/12

Parent Item Name: Floor Window

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-09 JLM  
IPP Rev: B Water jet/ecn798 06-05-08 EC  
IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			140	sf	180.1490	0.9745	2.051579	6		B1212-11	

Location	Loc Qty	Loc Code
MAT019	180.149	
110633	3	
117324	0.2467	
117431	10.7967	
119591	15.16	
121850	44.5456	
123704	106.4	123704

(S)

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS														
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Part No. _____			Work Order Update _____																	
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Heat Treat	Countersink	Mislabeled	Positioned Wrong																	
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge																	
Ripples in Bend	Drill Holes	Offset	Other																	
Torque Waves in Extrusion	Drawing	Out of Calibration																		
Turning Sequence	Finish	Out of Sequence																		
Wave/Twist in Tube	Folio	Outside Dimensions																		

DART AEROSPACE LTD	Work Order:	93837
Description: Floor Window	Part Number:	D3212-1
Inspection Dwg: D3212 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	Ofe   b.a	Audited by:	BC	Preliminary Approval:	
Date:	2013-01-13	Date:	2013-01-14	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	

